

Date: Monday, 28/05/2007 2:23:18 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WINDOW ASSEMBLY
Job Number : 32272B	
Estimate Number : 10304	
P.O. Number : <i>N/A</i>	Part Number : D3136043
This Issue : 28/05/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3136 REV D
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : 10/05/2007 Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 29383B	Material : <i>N/A</i>
Written By : _____	Due Date : 10/06/2007 Qty: 4 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:A 04.02.04 New issue KJ/DS	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: THERMOFORMING MACHINE
 MAKE AS PER DRWG
 D3136 REV.D

OK 07/05/30 Sample for Details

2.0	MACRLICS125	1/8" Polycast II Sheet
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Comment: Qty.: 4.4700 sf(s)/Unit Total : 17.8800 sf(s)
 1/8" Polycast II Sheet

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

[Signature]

N/A

4.0	D31089	Decal
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part#	Description	Batch
2	D3108-9	Decal	

B22608

OK 07/05/31

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Trim back masking film as per Dwg D3136 and apply D3108-9 decals to inside surface of windows.

2-Engrave Part number and Batch number as per Dwg D3136

OK 07/05/31

Date: Monday, 28/05/2007 2:23:18 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW ASSEMBLY

Job Number: 32272B

Part Number: D3136043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



07/06/20



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1.



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/06/20 (4)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

07/06/20

Job Completion



U 07/06/22

- 1.1.) TRIM BLANKS 4 pieces 26.75" x 21.5" M. 103735 MACRYLIC .125"
1.2.) FORM AS PER Doc 3136 Rev.D. D. 07/05/30
1.3.) FINISH TRIM AND POLISH EDGES D. 07/05/31
4) Pick LABELS B 22608 D. 07/05/31
5) Engrave Part number + Batch, Apply LABELS D. 07/05/31
Rework, 1 window 07/06/20 D.

Date: Thursday, 5/10/2007 2:24:14 PM
User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WINDOW ASSEMBLY
Job Number :	32272B		
Estimate Number :	10304		
P.O. Number :		Part Number :	D3136043
This Issue :	5/10/2007	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3136 REV D
First Issue :	/ /	Project Number :	N/A
Previous Run :	29383B	Drawing Revision :	D
		Material :	
Written By :		Due Date :	6/10/2007
Checked & Approved By :	<u>07.05.10</u>	Qty:	4 Um: Each
Comment :	Est Rev:A 04.02.04 New issue KJ/DS		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING
Issue P/O: _____
Order D3136-3 per Dwg D3136
Supplier: -Canus
Fabricate as per Dwg D3136
Apply 3M Protective Masking Film on top side only as per Dwg D3136
Material release note required

2.0	D31363	WINDOW
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
WINDOW

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5.0	D31089	Decal
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick:
Qty Part# Description Batch
2 D3108-9 Decal _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:24:14 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW ASSEMBLY

Job Number: 32272B

Part Number: D3136043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Trim back masking film as per Dwg D3136 and apply D3108-9 decals to inside surface of windows.

2-Engrave Part number and Batch number as per Dwg D3136

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



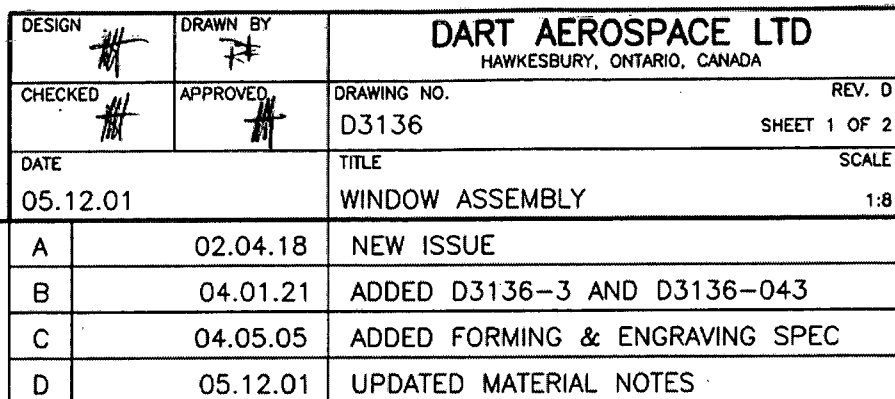
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

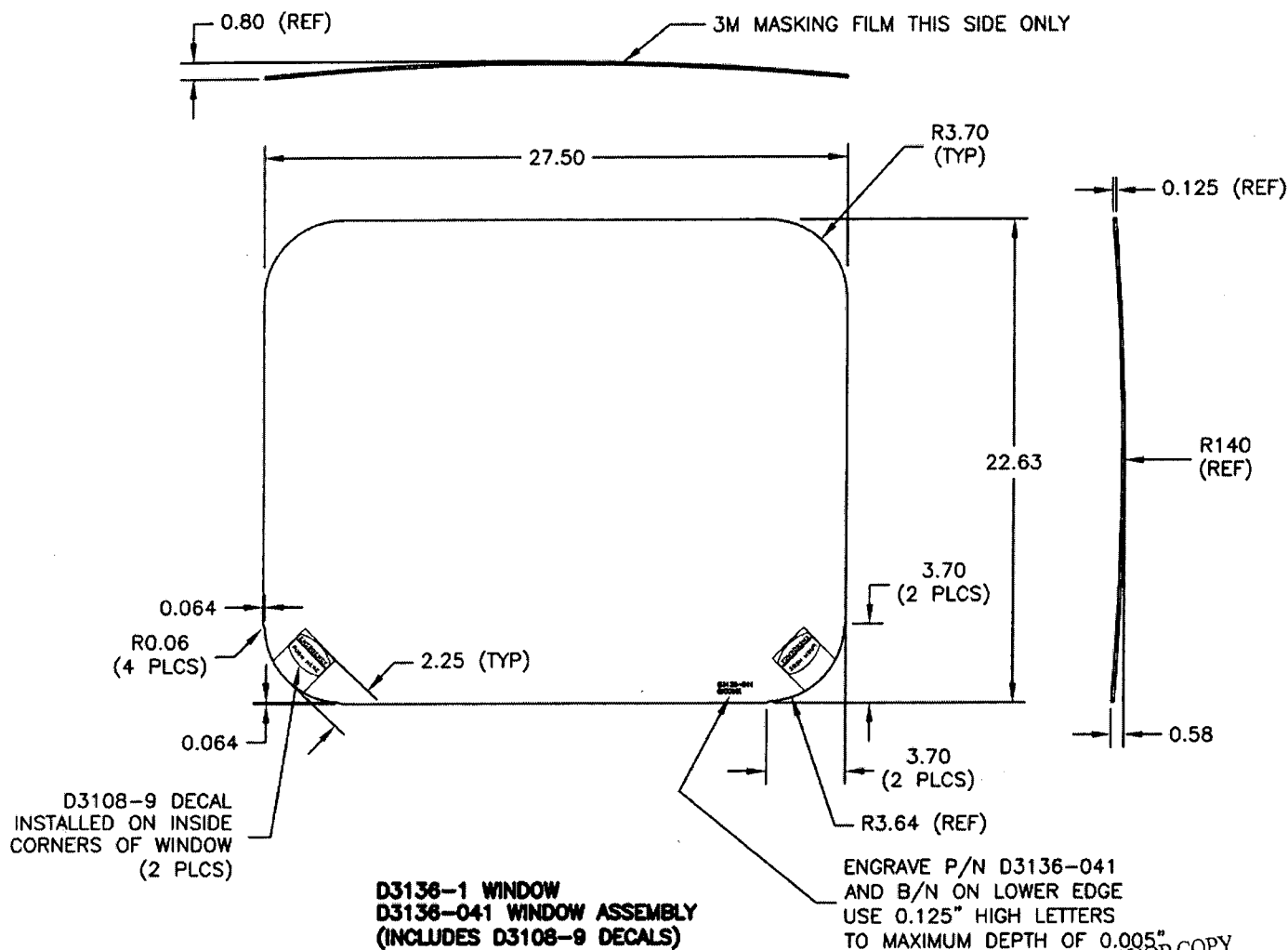
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
05.12.01



NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G
CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F
b) DRAPE OVER D3136-T1 MOLD & CLAMP
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS
d) TRIM PER TEMPLATE D3136-1T2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

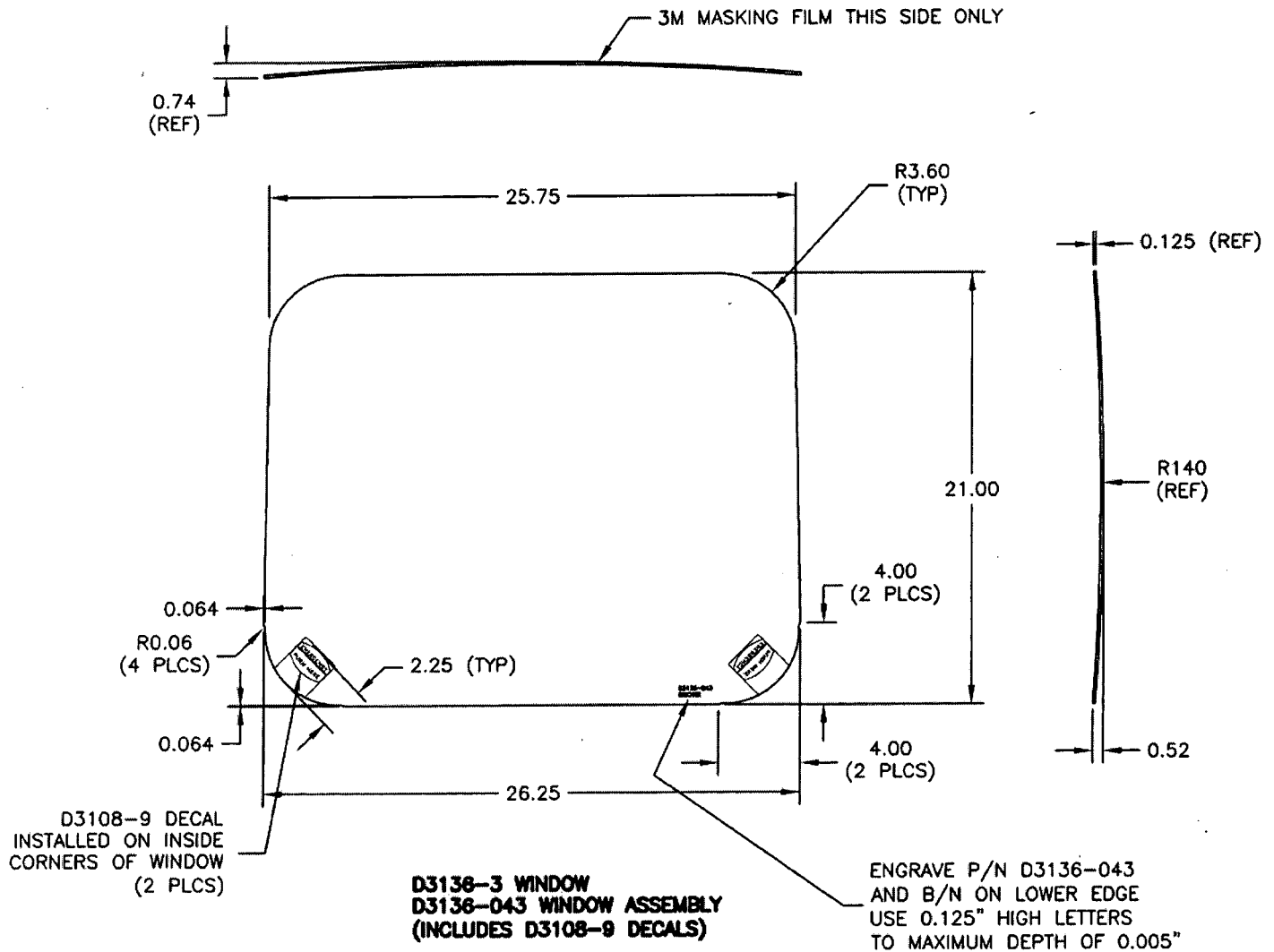
4 OF 0.005"
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3136	REV. D SHEET 2 OF 2
DATE 05.12.01		TITLE WINDOW ASSEMBLY	SCALE 1:8

RELEASED
05.12.01 *[Signature]***NOTES:**

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F
b) DRAPE OVER D3136-T1 MOLD & CLAMP
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS
d) TRIM PER TEMPLATE D3136-3T1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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